

**WHAT IS CLAIMED IS:**

101. A transistor in a semiconductor device, comprising:  
source/drain diffusion regions formed on a semiconductive region of a substrate; and  
a transistor gate formed on the semiconductive region between the source/drain  
diffusion regions, the transistor gate extending in a vertical orientation from the substrate,  
the transistor gate comprising at least two overlying layers of epitaxially grown silicon, each  
epitaxial layer having insulated sidewalls, and an uppermost layer having an insulated top  
surface.
102. The transistor of Claim 101, wherein the source/drain diffusion regions are elevated  
and extend in a vertical orientation from the substrate surface adjacent to the transistor gate.
103. The transistor of Claim 102, wherein each of the source/drain diffusion regions  
comprise at least two overlying layers of epitaxially grown silicon, each epitaxial layer  
having insulated sidewalls, and an uppermost layer having an insulated top surface.
104. The transistor of Claim 103, wherein the source/drain diffusion regions comprise an  
uppermost epitaxial layer comprising a conductivity enhancing dopant.
105. The transistor of Claim 103, wherein each of the epitaxial layers of the source/drain  
diffusion regions comprise a conductivity enhancing dopant.
106. The transistor of Claim 101, wherein each epitaxial layer comprises a faceted top  
surface.
107. The transistor of Claim 101, wherein each epitaxial layer has a thickness of about 50  
to about 200 nm.
108. The transistor of Claim 101, wherein the transistor is isolated within the substrate by  
at least one dielectric isolation region formed in the substrate adjacent thereto.

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109. The method of Claim 108, wherein the at least one dielectric isolation region is a shallow trench isolation region comprising an oxide.

110. A transistor in a semiconductor device, comprising:  
a transistor gate formed on a semiconductive region of a substrate; and  
elevated source/drain diffusion regions formed on the semiconductive region adjacent to the transistor gate, and extending in a vertical plane from the substrate;  
each of the source/drain diffusion regions covered by a layer of insulative material and comprising at least two overlying layers of epitaxially grown silicon.

111. The transistor of Claim 110, wherein the source/drain diffusion regions comprise an uppermost epitaxial layer comprising a conductivity enhancing dopant.

112. The transistor of Claim 110, wherein at least one of the epitaxial layers of the source/drain diffusion regions comprise a conductivity enhancing dopant.

113. The transistor of Claim 112, wherein at least one of the epitaxial layers comprises a concentration gradient of the dopant.

114. The transistor of Claim 110, wherein the epitaxial layers comprise a faceted top surface.

115. The transistor of Claim 110, wherein each epitaxial layer has a thickness of about 50 to about 200 nm.

116. The transistor of Claim 110, wherein the transistor gate is covered by a layer of insulative material and comprises at least two overlying layers of epitaxially grown silicon.

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117. A transistor in a semiconductor device, comprising:  
a substrate having a buried drain region;  
a gate overlying the buried drain region, the gate comprising multiple, vertically-oriented and overlying epitaxial layers and a top surface, each epitaxial layer having insulated sidewalls;  
a source region overlying the top surface of the gate, the source region comprising an epitaxial layer doped with a conductivity enhancing dopant, and covered by a layer of insulative material.

118. The transistor of Claim 117, wherein each of the epitaxial layers of the gate is about 50 to about 200 nm thick.

119. The transistor of Claim 117, wherein the epitaxial layer of the source region is at least about 10 nm thick.

120. The transistor of Claim 117, wherein the epitaxial layers have a faceted top surface.

121. The transistor of Claim 117, wherein the buried drain comprises an n-type conductivity enhancing dopant an n-type selected from the group consisting of phosphine, arsine, and combinations thereof.

122. The transistor of Claim 117, wherein the buried drain region is about 50 nm to about 100 nm wide.

123. A transistor in a semiconductor device, comprising:  
a transistor gate disposed on a semiconductive region of a substrate; and  
an elevated source/drain diffusion region disposed on the substrate adjacent to the transistor gate in a vertical orientation from the substrate; the source/drain diffusion region comprising at least two overlying layers of epitaxially grown silicon; each epitaxial layer having a top surface, and sidewalls with an overlying layer of an insulative material, and the

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uppermost epitaxial layer having a top surface with an overlying layer of an insulative material.

124. The transistor of Claim 123, wherein at least one of the epitaxial layers of the source/drain diffusion region comprises a conductivity enhancing dopant.

125. The transistor of Claim 124, wherein the uppermost epitaxial layer of the source/drain diffusion region comprises a conductivity enhancing dopant.

126. The transistor of Claim 124, wherein at least one of the epitaxial layers comprises a concentration gradient of the dopant.

127. The transistor of Claim 124, wherein the conductivity enhancing dopant comprises a p-type dopant.

128. The transistor of Claim 124, wherein the conductivity enhancing dopant comprises an n-type dopant.

129. A semiconductor structure, comprising:  
comprising at least two overlying layers of epitaxially grown silicon, each epitaxial layer having insulated sidewalls, and an uppermost epitaxial layer having an insulated top surface; the structure disposed on a substrate in a vertical orientation.

130. The semiconductor structure of Claim 129, wherein each epitaxial layer comprises a top surface defining a facet.

131. The semiconductor structure of Claim 130, wherein the facet has a (100) plane orientation.

132. The semiconductor structure of Claim 129, wherein each epitaxial layer has a thickness of up to about 200 nm.

133. The semiconductor structure of Claim 132, wherein each epitaxial layer has a thickness of about 50 to about 200 nm.

134. The semiconductor structure of Claim 132, wherein one or more epitaxial layers has a thickness of about 70 to about 100 nm.

135. The semiconductor structure of Claim 132, wherein each epitaxial layer has a thickness of at least about 10 nm to about 30 nm.

136. The semiconductor structure of Claim 129, being disposed adjacent to a gate or word line.

137. The semiconductor structure of Claim 129, being disposed adjacent to a source/drain region.

138. The semiconductor structure of Claim 137, being a transistor gate.

139. The semiconductor structure of Claim 138, wherein the transistor gate is isolated within the substrate by at least one dielectric isolation region disposed in the substrate adjacent thereto.

140. The semiconductor structure of Claim 129, being a source/drain diffusion region.

141. The semiconductor structure of Claim 140, wherein the uppermost epitaxial layer comprises a conductivity enhancing dopant.

142. The semiconductor structure of Claim 140, wherein each of the epitaxial layers comprises a conductivity enhancing dopant.

143. A semiconductor structure, comprising:

at least two overlying layers of epitaxially grown silicon, each epitaxial layer having a top surface, and sidewalls with an overlying layer of an insulative material, an uppermost epitaxial layer having a top surface with an overlying layer of an insulative material; and the structure disposed on a substrate in a vertical orientation.

144. The semiconductor structure of Claim 143, wherein the insulative layer comprises an oxide film, a nitride film, an oxidized nitride film, or a composite oxide/nitride film.

145. The semiconductor structure of Claim 144, wherein the insulative layer comprises a silicon nitride film.

146. The semiconductor structure of Claim 145, wherein the silicon nitride film has a thickness of about 5 to about 20 nm.

147. The semiconductor structure of Claim 144, wherein the insulative layer comprises a silicon oxide film.

148. The semiconductor structure of Claim 147, wherein the silicon oxide film has a thickness of about 2 to about 5 nm.

149. A semiconductor structure, comprising:

at least two overlying layers of epitaxially grown silicon, each epitaxial layer having a top surface, and sidewalls with an overlying layer of an insulative material; an uppermost epitaxial layer having a top surface with an overlying layer of an insulative material; one or more of the epitaxial layers comprising a conductivity enhancing dopant; and the structure disposed on a substrate in a vertical orientation.

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150. The semiconductor structure of Claim 149, wherein the conductivity enhancing dopant comprises a p-type dopant.

151. The semiconductor structure of Claims 150, wherein the p-type dopant is selected from the group consisting of diborane, boron trichloride, and boron trifluoride, and combinations thereof.

152. The semiconductor structure of Claims 149, wherein the conductivity enhancing dopant comprises an n-type dopant.

153. The semiconductor structure of Claims 152, wherein the n-type dopant is selected from the group consisting of phosphine, arsine, and combinations thereof.

154. The semiconductor structure of Claims 149, wherein one or more of the epitaxial layers comprises a concentration gradient of the dopant within the epitaxial layer.

155. The semiconductor structure of Claims 154, wherein the concentration gradient comprises a low to high concentration of the dopant within the epitaxial layer, with the high dopant concentration at the top surface of the layer.